

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023263**Date Inspected:** 04-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AE and Seg 13BE:

ABF personnel performing Magnetic Particle testing (MT) on weld joint nos: OBE13B-002 (Bottom Panel to Bottom Panel) and OBE13-002 (Deck Panel to Deck Panel) complete joint penetration (CJP) splice welds. MT was observed to be done after completion of hot pass of the weld. See attached photos for further details.

OBG Seg 13AW:

Repair welding of weld joint no: Seg3013AD-035 [Floor Beam to Side Panel, CJP weld at Panel Point (PP) 120]. The welder is identified as 067765 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS):

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345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2935 Rev-0. See attached photo for further details.

Grillage Assembly on Seg 13AW:

ZPMC personnel performing fit-up of steel backing bar on weld joint nos: Seg3013F-039, Seg3013H-037 and Seg3013K-038 (Floor Beam to Deck Panel Diaphragm CJP welds at PP119+1500, PP119 and PP119-1500; respectively). It was observed that the backing bars are in 2 pieces (at each joint). However, the joint needs to be welded as a CJP weld with back gouging. See attached photo for further details.

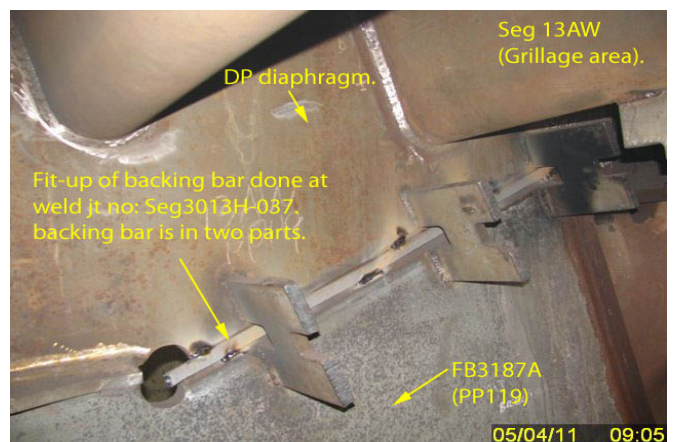
OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013L-099 [Floor Beam to I-rib stiffener, CJP weld at PP119-1500]. The welder is identified as 067103 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 14W:

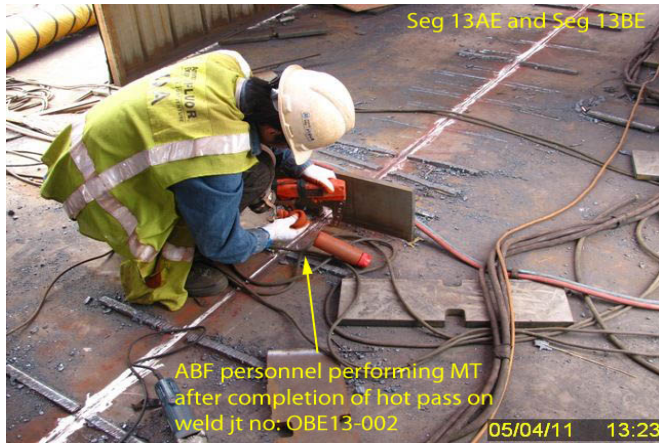
The SMAW process on weld joint no: Seg3020AH-002 [Side Panel (SP) 3144B to Edge Panel (EP) 3029A, CJP weld at PP125 to PP127]. The welder is identified as 037932 and was observed welding in 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer